

Work Order ID 63290

Wednesday, October 27, 2010 10:18:06 AM



Page 1

Item ID: D212-725-1-223F

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *10/27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	E								

100

0.00



Waterjet

Memo

0.00

B 10-10-29

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *F*

Prog Rev: *F*

304 .020

2-Deburr if necessary

Q

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B 10-10-29

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SB 10/10/29

(+2)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/10/29

(+2)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/10/29

(+2)

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

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Item Name: Angle

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Comp 29 (2)10/10/29mr
10-10-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, October 27, 2010 10:18:10 AM

Page 1

Work Order ID: 63290



Parent Item: D212-725-1-223F



Parent Item Name: Angle


Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA  304/316 .020" Sheet		Purchased	No			100	sf	19.1900	0.0181	0.038105			



B10-10-29

Location

Loc Qty

Loc Code

MAT20

19.19

107436

16.19

107513

3

107436

Q

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63290
Description: ANGLE		Part Number: DAD-725-1-223F
Inspection Dwg:	Rev: E	Page 1 of 1

DAD-725-1-223F

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	$\pm .030$	2.299	X		V 1302	
1.80	$\pm .030$	1.798	X		V	
.900	$\pm .010$.899	X		V	
.25	$\pm .030$.251	X		V	
1.14	$\pm .030$	1.141	X		V	
.16	$\pm .030$.160	X		V	
.20	$\pm .030$.196	X		V	
1.60	$\pm .030$	1.600	X		V	
.800	$\pm .010$.799	X		V	
1.900	$\pm .010$	1.900	X		V	
.25	$\pm .030$.246	X		V	
.64	$\pm .030$.64	X		V	
Ø .098	$\pm .004 - .001$.102	X		V	
.030	$\pm .010$.024	X		V	

Measured by: KB	Audited by: S	Prototype Approval:
Date: 10-10-79	Date: 10/10/79	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

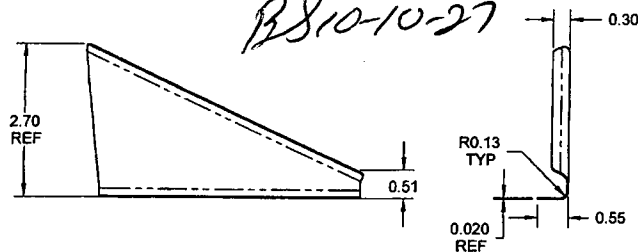
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

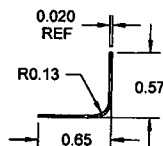
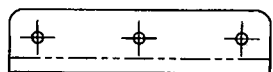
WITHOUT NOTICE
WORK ORDER

NO. 43290

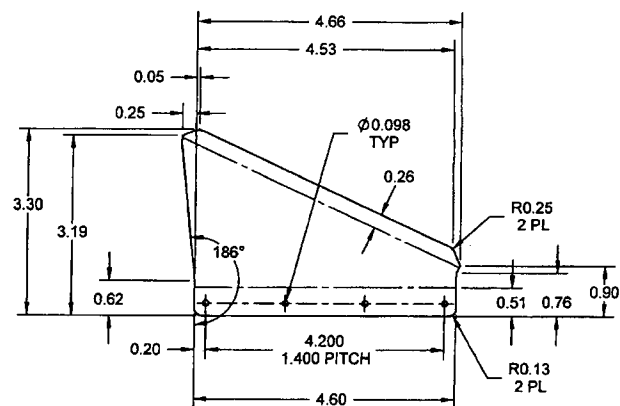
BS10-10-27



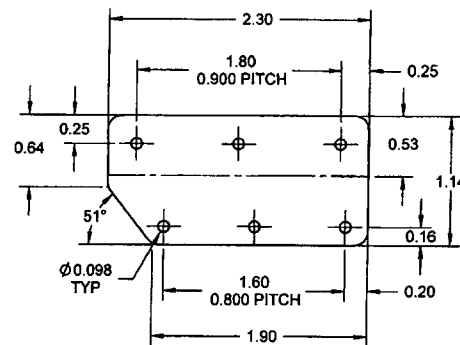
D212-725-1-221 GUSSET
(MAKE FROM D212-725-1-221F FLAT PATTERN)
SCALE 0.5X



D212-725-1-223 ANGLE
(MAKE FROM D212-725-1-223F FLAT PATTERN)



D212-725-1-221F FLAT PATTERN
(SCALE 0.5X)



D212-725-1-223F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316/321 ANN STAINLESS STEEL 0.020 (25 GAUGE) SHEET PER AMS-5513/-5524/-5510
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 78 OF 82
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2009-10-28
[Signature]

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